



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBSC7028-P
Job Sheet 200677

Part No: RBSC7028-P		Job Qty: 2 pcs
Part Name: Portable Bearing Cutter		
Part Weight: 0 lbs	Status: New	Priority: Medium
Job Created: 9/16/19	Job Tracking No:	
Due Date: 9/20/19	Created By: Patrick Lussier	
Type: Stock	Description:	
Note: DWG RBSC7028-P REV:6 IPP REV A 18.02.12 NEW ISSUE RQ VERIFIED BY DP		
Ship Via:		

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
92	Purchasing	2 pcs	9/20/19	9/20/19	0.00	0.00	Purchasing - 1		DP SEP 17 2019
							Purchasing - 2		
							Purchasing - 3		
94	Packaging 2-1 - Receive - B4B	2 pcs	9/20/19	9/20/19	0.00	0.00	Packaging 2 - 1 - B4B		DP SEP 17 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S214436

Part: RBSC7028 - P
Job No: 200677
Serial No/Batch: S214436
Revision: 6
Inspector:
Exp Date:
Instructions:

Date: 09/17/19

96 QC 6	2 pcs	9/20/19	0.00 0.00	Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	81
				QC 6 - 81	9-89
					SEP 18 2019
97 Small Fab - 2 - B4B	2 pcs	9/20/19	0.00 0.25	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	

Part Op 92 - (Purchasing) Issue PO to ARROW TECH MACHINE WORKS P/O: 4604435 MANUFACTURE RBSC7028-P AS
Descriptions: PER DWG -Certificate of conformity is required
94 - (Receive & Inspect for Damage & Mat'l Certs)
96 - (QC6- All purchased or subcontracted products)
97 - Pick and pack case.

x2 

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBSC7028-PP	Portable Bearing Cutter	2 pcs (1 ea)	92-Purchasing	5214432
10137	Small Pistol Case, Plastic	2 Ea (1 ea)	97-Small Fab - 2 - B4B	
5475A12	Fixed Pin Spanner Wrench	2 Ea (1 ea)	97-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
92-Purchasing	RBSC7028-PP	2	0	0
97-Small Fab - 2 - B4B	10137	2	5	0
	5475A12	2	4	0

Part Specifications				
Specifications could not be found.				

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BEARINGS AND TOOLS COVERED	
BEARING #	TOOL #
406-310-403-101	RBSC7008-P
206-010-470-101	RBSC7028-P
406-312-100-101	RBSC7048-P
412-010-182-103	RBSC7188-P

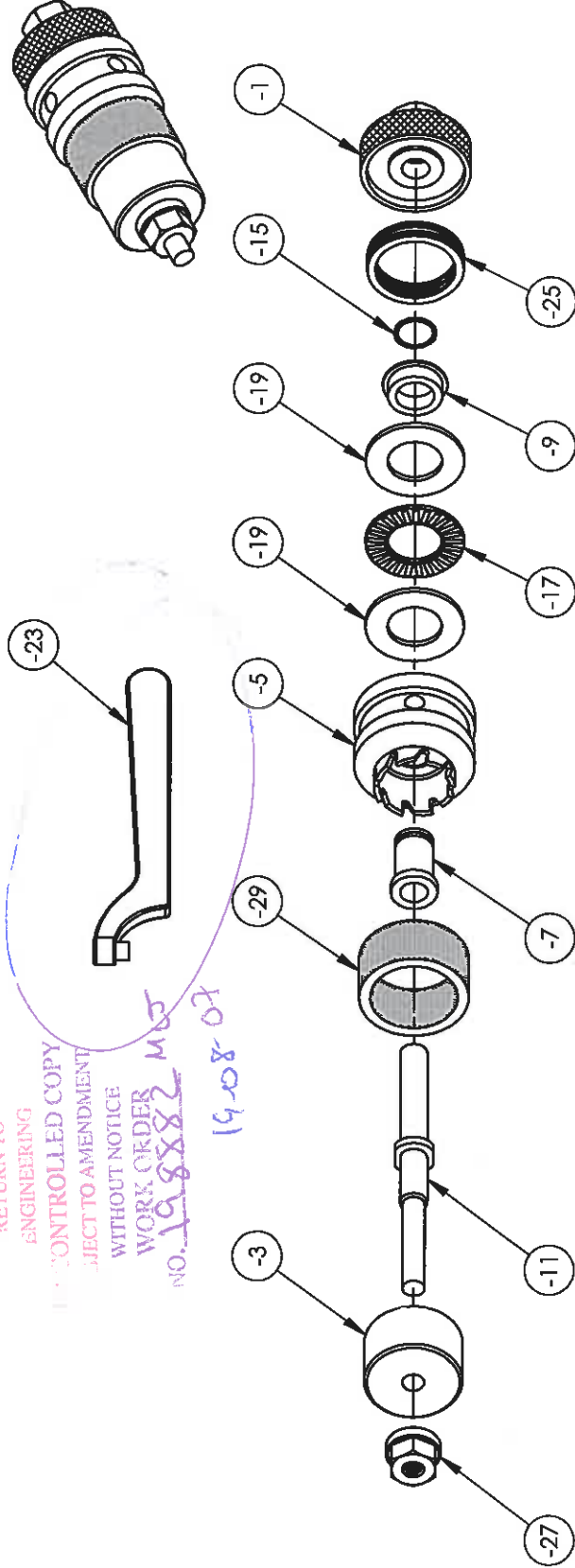
REVISIONS

REV	ECR	DESCRIPTION	DATE	INIT.
1		CHANGED TOOL # RBSC412-010-103-P TO RBSC7188-P TO CLARIFY TOOLING IDENTIFICATION.	11/6/09	WP
2		ADDED NEW BRG. CUTTER RBSC7048-P FOR BEARING #406-312-100-101 PER E.B.	5/2/11	RJC
3		CH'D -3 FROM .312, CORRECTED -11 SCALE TO REFLECT PART REPRESENTATION PER S.E.	6/24/11	RJC
4		-5 CH'D DIM SCHEME, REDREW SECTION VIEW.	7/13/2015	BM
5	15-0470	UPDATED TO NEW DRAFTING STANDARDS, ADDED NEW BEARING MODELS.	7/13/2015	SM
6	16-0112	UPDATED TO NEW STANDARD, ADDED CASE RSR GROUP #10137 TO BOM. -1 CH'D MATL WAS 1018 IS 1018/1020 CR. CH'D DIMS WAS Ø.425 (S Ø.43 WAS 5/16-24 UNF IS 5/16-24 UNF-28. -3 CH'D MATL WAS 4140 Q&T RND BAR IS 4140/4142. CH'D DIM WAS .032 X .45" IS .03 X .45". ADDED HEAT TREAT AND SPEC. -5 CH'D DIMS WAS R.030 IS R.03. WAS .015 X .45" IS .02 X .45". WAS R.015 MAX IS R.02 MAX. ADDED DIM 4X Ø.219 ±.23 EQUALLY SPACED, ADDED SPEC. -11 CH'D MATL WAS 4140 Q&T IS 4140/4142. ADDED HEAT TREAT AND SPEC. CH'D DIMS WAS 1/4-20 MACHINE THREADS IS 1/4-20 UNC-2A. WAS 5/16-24 MACHINE THREADS IS 5/16-24 UNF-2A.	8/11/2016	DEW
				SM

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ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198882 MOD

19-08-07



ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	SPRING TENSIONER	1018/1020 CR		2
		-3	1	SEAT	4140/4142		3
		-5	1	CUTTER	O-1		4
		-7	1	GUIDE	BRONZE		5
		-9	1	BUSHING	BRONZE		6
		-11	1	STUD	4140/4142		7
	B/O	-15	1	SPIRAL EXTERNAL RETAINING RING	STEEL	Ø77/16 SHAFT (MCMASTER-CARR # 91465A350)	1
	B/O	-17	1	THRUST BEARING	STEEL	Ø 5/8 ID. X 1-1/8 OD. X 5/64 (APPLIED # NTA-1018)	1
	B/O	-19	2	THRUST WASHER	STEEL	Ø 5/8 ID. X 1-1/8 OD. X 1/16 (APPLIED # TRB-1018)	1
	B/O	-23	1	FIXED PIN SPANNER WRENCH	STEEL	Ø 1-1/4 OD. X Ø 13/64 PIN (MCMASTER-CARR # 5475A12)	1
	B/O	-25	1	CREST TO CREST SPRING	STEEL	SMALLEY CO. # CS112-H2	1
	B/O	-27	1	ROTATING FLANGE NUT	STEEL	1/4-20 ROTATING FLANGE NUT (MCMASTER-CARR #90477A029)	1
	B/O	-29	1	TOOTH GUARD (FOR SHIPPING ONLY)	VINYL	SEE -5 Ø8 PAGE 4 FOR INSIDE DIA. OF TUBE X 5/8 LENGTH	1
	B/O	-31	1	CASE	PLASTIC	(RSR GROUP # 10137)	N/S

DART
AEROSPACE

TITLE RBSC7###-P SERIES PORTABLE BEARING
CUTTERS FOR BELL BEARINGS

REV 6

DWG NO.

RBSC7###-P

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ARE TO BE USED
XX ±.01 ANGLES ±.5°
X ±.1 SURFACES ±.125
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL

SCALE 1:2

DATE

7/13/2015

SHEET 1 OF 7

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.		Route update only											
Job: _____		DISPOSITION				DEPARTMENT/PROCESS							
Part No. _____		Rework Scrap Use-as-is				Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)							
Description Work Order Deviation						Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors						FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
Completed By						Lead hand / Supervisor							
QC / QA Coordinator													



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044235



Supplier: ARR002-VU Arrow Tech Machine Works 29751 E. Enid Road, Unit C Eugene, OR 97402 USA Phone: 541-780-6938 Fax: 458-215-4938	PO No: POHB044235 PO Date: 8/9/19 Due Date: 9/20/19 Purchase Order Revision: Revision Date: Ship-To Contact: Phone: Pymt Terms: Net 30 Freight Terms: Special Comments:
Attention: , Ana (541) 780-6938	
Ship To:	

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	190002	RBSC7028-PP Cutter As Per Dwg RBSC7028-P Rev.6			Portable Bearing Cutter As Per Dwg RBSC7028-P Rev.6	Firmed X2	-	9/20/19	2 pcs	0 pcs	2 pcs	\$1,481.00/pcs	\$2,962.00
Grand Total:												\$2,962.00	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/9/19 1:24 PM dart.lussier@plex.com



PHGE Machineworks dba
Arrowtech Machineworks
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 700

Date: 9/12/2019
PO Ref: HB044235
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
2	PORTABLE BEARING CUTTER	RBSC7028-P REV-6

RECEIVED
SEP 13 2019
DART AEROSPACE LTD.

Received by: _____
Packaged by: J.M.L. _____
Checked by: AUP _____

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044235 Dated: 9/12/2019

Our Order / Job No: AWT-HB044235 Order Qty: 2

Part Name: PORTABLE BEARING CUTTERS FOR BELL BEARINGS

Part Number RBSC7028-P

Lot Size: N/A Ship Date: 9/12/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBSC7028-P Rev: 6

Material Size and Type: -1/1018 STEEL; -3, -11/4140 Q&T STEEL; -5/O1 ALLOY; -7, -9/BRONZE

Material Specifications: STEEL: ASTM A108; O1 STEEL: ASTM A681; BRONZE: B505

Heat Treatment: (-3, -11 /28-32 RC); -5/ 56 RC

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 09.12.19

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
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Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com